

# Work Order ID 73456



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Thursday, September 01, 2011 7:32:50 AM

Item ID: D2365	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearplate				
Start Date: 8/31/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 9/16/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/09/01</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2365	Rev C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2365	<input type="checkbox"/> Dwg Rev: <u>C</u>	<input type="checkbox"/> Prog Rev: <u>C</u>	<input type="checkbox"/> 2-					
6061 . 063	Deburr if necessary								

B1-10-31

(30)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B1-10-31

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

11 / 11 / 01 (30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73456**

Thursday, September 01, 2011 7:32:50 AM



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Item ID: D2365

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/31/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				30	BR	11-1-11	
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
150  Small Fab Small Fab Small Fab	Small Fab  Memo Install Insert as per Dwg D2365	0.00  0.00							

30XØ m-11/11/01

EB 11/11/01 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Thursday, September 01, 2011 7:32:50 AM



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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<i>MF</i>	11	11	01 (30)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>01/</u>  Memo	0.00  0.00							<i>Ed/0/01</i> (30)
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/11/02 <i>[Signature]</i>  <i>MF</i> 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 7:32:48 AM

Page 1

Work Order ID: 73456

Parent Item: D2365

Parent Item Name: Wearplate



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM  
(IPP Rev:B Now On Waterjet 08-04-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF 		Purchased	No			100	Each	0.0000	2	24			
PEM Insert													
M6061T6S.063 		Purchased	No			150	sf	205.1256	0.0047	0.059368	.5		
6061-T6 .063 Sheet													

B71756 (40)

8/31/11/01

1311-10-31

## Location

MAT021

116308  
117285  
118580

## Loc Qty

205.1255684  
26.9755684  
105.15  
73

## Loc Code

116308  
\_\_\_\_\_  
\_\_\_\_\_

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

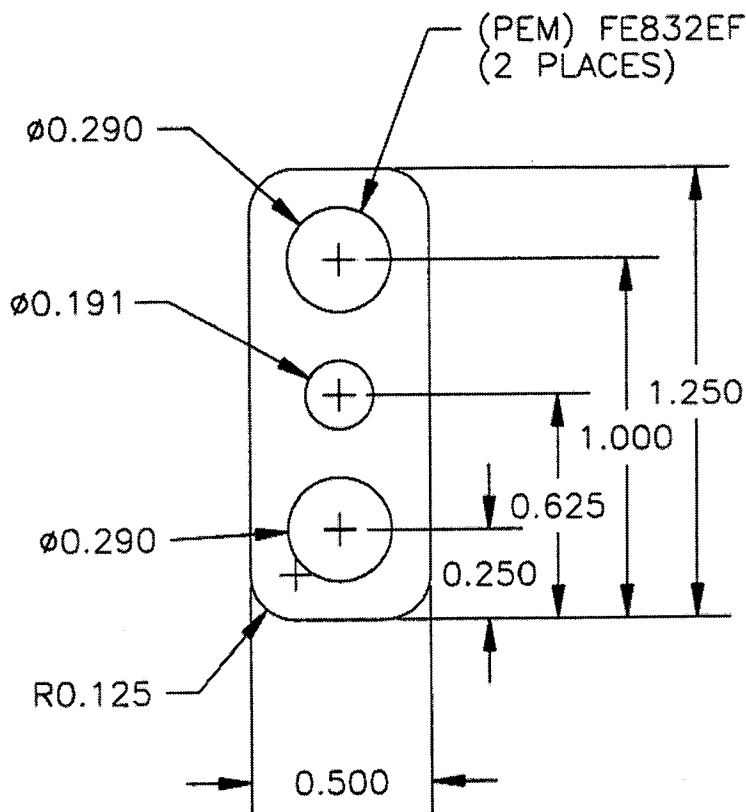






DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2365	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED  
17/04/22 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73156  
CL11/09/01

6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26  
ACID ETCH & ALODINE PER QSI DQS 4-1-1 } #  
INSTALL FE832EF (2 PLS) AFTER ALODINE }  
~~AKS 304/316 SS~~  
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK } # 00.03.07  
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES } #